

Date: Wednesday, 11/22/2006 1:39:15 PM  
 User: Kim Johnston

## Process Sheet

SPLIT?

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 29646  
 Estimate Number : 10256  
 P.O. Number : N/A Part Number : D22303  
 This Issue : 11/22/2006 S.O. No. : N/A Drawing Number : D2230 REV F  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F  
 Previous Run : 29601 Material : N/A  
 Written By : AW Due Date : 12/10/2006 Qty: 300 Um: Each  
 Checked & Approved By : AW 06 11 22  
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s)  
 Lug Extrusion  
 D2423  
 Batch: 23779

M8/56 06/11/22 300

2.0 BAND SAW BAND SAW



Comment: Band Saw  
 Cut D2423 extrusion to 0.82"  
 Batch: 23779

M8/56 06/11/22 300

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per folio D2230-3  
 Check for crack while loading into the machine.

Issue P.O. 2556 c2061+1124  
 Machine per drawing D2230 Rev.F

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Review + Inspect for 104/11/29 (95) ?  
 tensile damage 100

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect level 5 11/29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AP Date: 06/12/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Wednesday, 11/22/2006 1:39:15 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 29646

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

N/A 11/29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m. 06/11/29 (100)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 11 29 (100)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

a.m. 06/11/30 (100)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

FC 06 11 30 (100)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57171

06/11/30 (3)

06/12/01 (99)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/01 (100)

Job Completion



06/12/01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

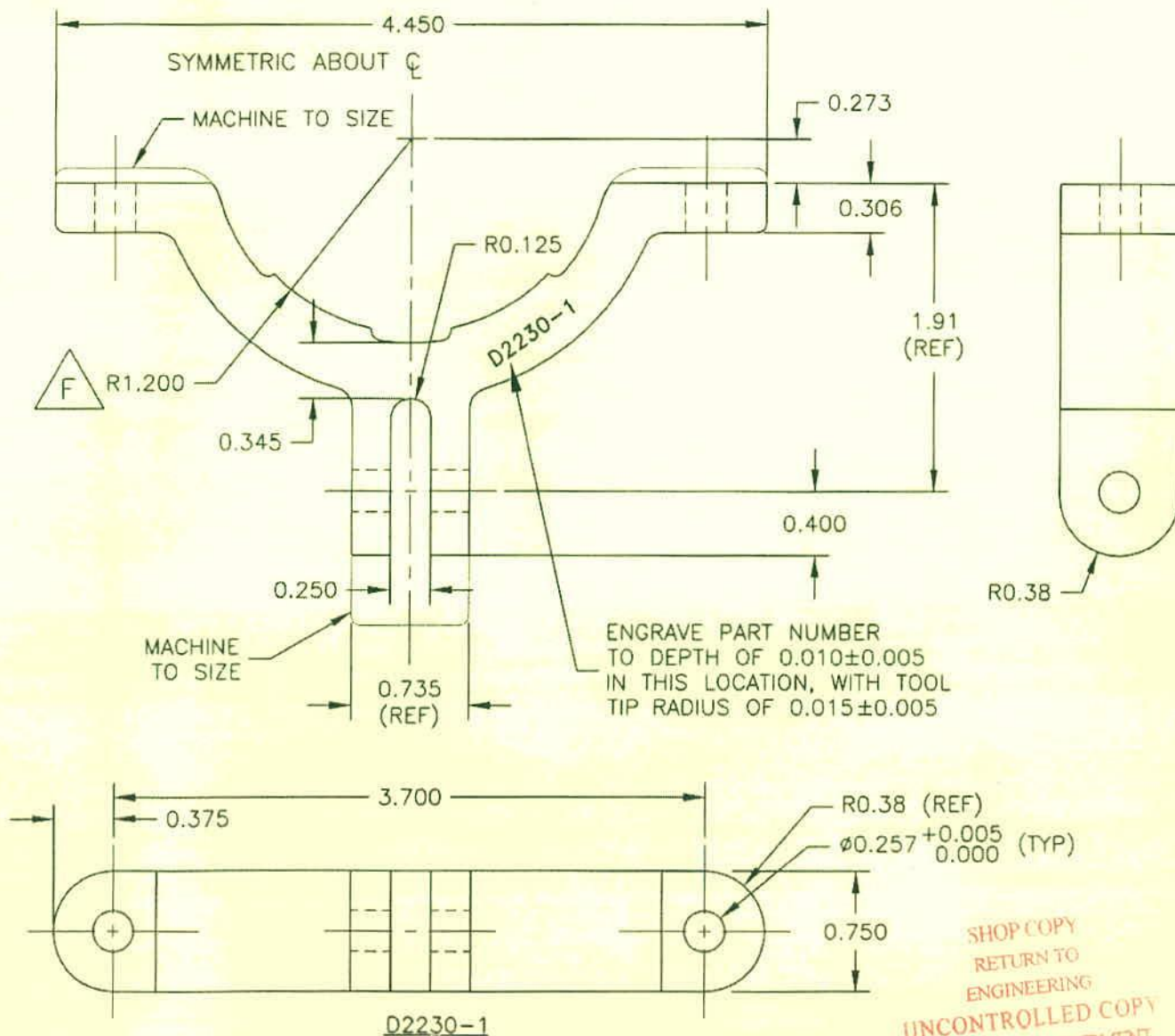
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2230                              | REV. F<br>SHEET 1 OF 2 |
| DATE<br>99.12.13              | TITLE<br>MOUNTING LUG          |   | SCALE<br>1:1           |
| C                             | 94.03.30                       | RE-DESIGN   |                        |
| D                             | 95.01.04                       | RE-DESIGN   |                        |
| E                             | 95.01.04                       | RE-DESIGN   |                        |
| F                             | 99.12.13                       | REDESIGN; R1.200 WAS R1.100                       |                        |

**RELEASED**  
99.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29646

1891. 1. 1. 1894.  
P. M. 1893. 1. 1.

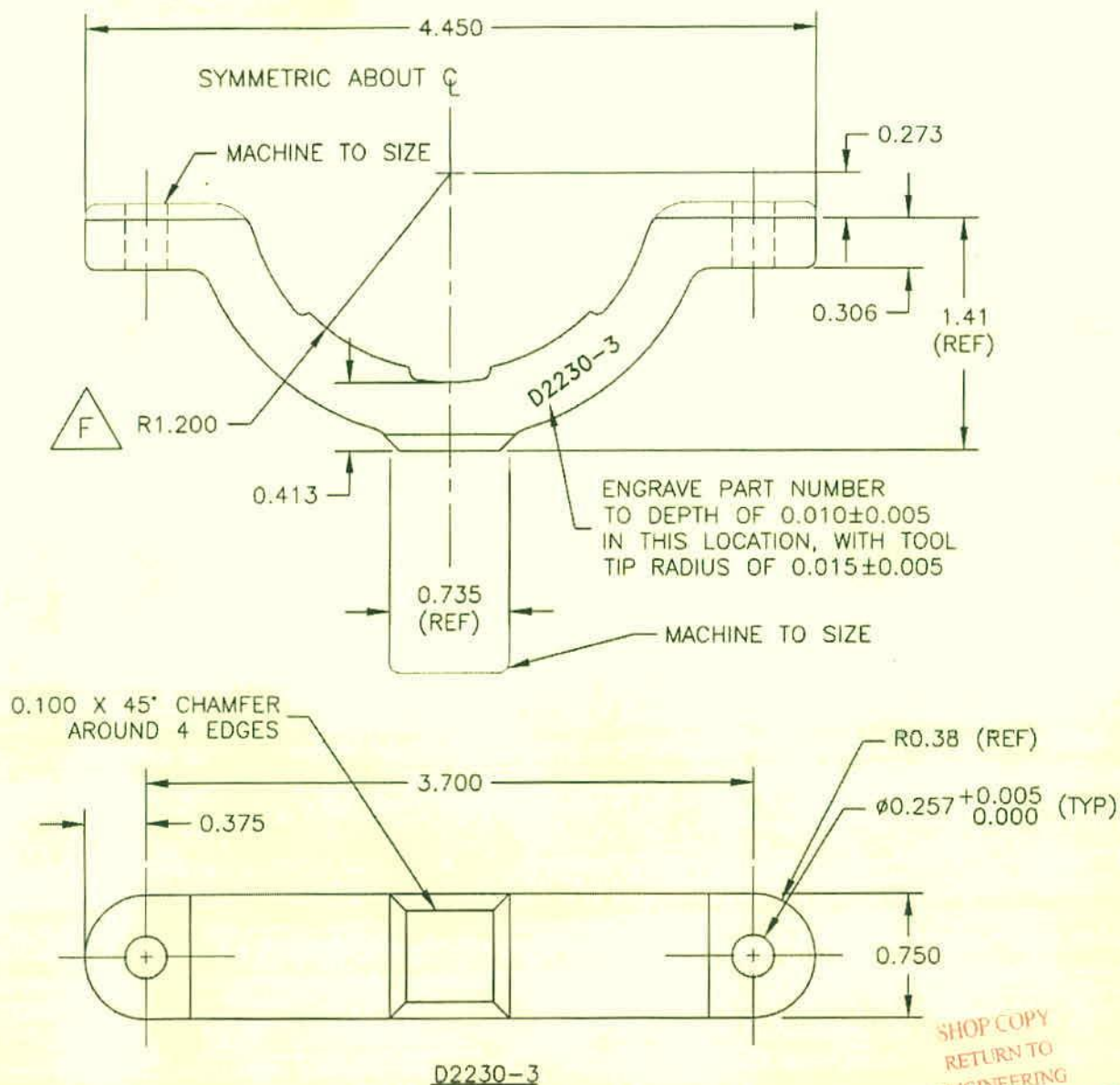
1891. 1. 1. 1894.  
P. M. 1893. 1. 1.





|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2230                              | REV. F<br>SHEET 2 OF 2 |
| DATE<br>99.12.13              |                                | TITLE<br>MOUNTING LUG                             | SCALE<br>1:1           |

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29646





### CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

11/06/12/01

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-3 ✓

Lug

2556

MATERIAL: supplied by DART B29646 D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Shigi (Regula) Walz

Vankleek Hill, November 29, 2006



